

Work Order ID 50952

July 28, 2009 8:41:49 AM

Page 1

Item ID: D2891-1

Accept

Revision ID: A1

Item Name: 2.25 Support

Setup Start

Stop

Start Date: 07/29/2009 Start Qty: 20.00

Required Date: 08/28/2009 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

09-07-28

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2891

Rev A1

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

DJP 09/07/29

20

HAAS CNC vertical machine #1

Machine as per Folio FA046 Tumble & Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

DJP 09/07/29

20

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

J.A 09/08/06

20

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50952

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:30am

OVEN TEMPERATURE:

8:00am FINISH TIME:

100°F

= 1/2 lb

09-08-10

X 20

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

9/8/11 200 SP

150

Identify as per dwg & Stock Location: ~~140~~

0.00

Packaging

Memo

0.00

Packaging

9/8/11 200 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50952

July 28, 2009 8:41:49 AM

Page 3

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Required Date: 08/28/2009 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

08-08-13
MLF 09-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 28, 2009 8:41:49 AM

Page 1/1

Work Order ID: 50952

Parent Item: D2891-1RevA1

Parent Item Name: 2.25 Support


Comments:

Start Date: 07/29/2009

Required Date: 08/28/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK076RevA		Manufactured	No			110	Each	15.0000	10.0000			
												
D2891-1 TURNING DETAIL												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

15

42244

1

43384

4

46923

10

DT 09/07/29

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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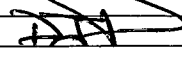
NOTE: Date & initial all entries

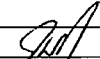
DART AEROSPACE LTD		Work Order: 50952
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.127	0.127	0.124	0.125	0.125
AD	0.040	0.060		0.052	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.020	0.020	0.020	0.020	0.020
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.130	0.140	0.138	0.138	0.139
AI	0.454	0.474		0.459	0.460	0.460	0.459	0.460
AJ	2.779	2.789		2.782	2.782	2.782	2.783	2.783
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.035	1.035	1.035	1.035	1.035
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683		1.676	1.676	1.676	1.676	1.676
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: 	Date: 09/07/29
Audited by: M. A	Date: 09/08/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50952
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	.188	.188
AB	0.240	0.260		0.250	0.250	0.250	.250	.250
AC	0.115	0.150		0.127	0.126	0.126	.127	.126
AD	0.040	0.060		0.050	0.050	0.050	.050	.050
AE	0.010	0.020		0.020	0.020	0.020	.020	.020
AF	0.240	0.260		0.250	0.250	0.250	.250	.250
AG	0.290	0.310		0.300	0.300	0.300	.300	.300
AH	0.115	0.150		0.138	0.138	0.138	.139	.139
AI	0.454	0.474		0.458	0.460	0.458	.457	0.458
AJ	2.779	2.789		2.782	2.782	2.782	2.782	2.783
AK	0.240	0.260		0.250	0.250	0.250	.250	.250
AL	1.002	1.042		1.032	1.035	1.035	1.035	1.035
AM	0.053	0.073		0.063	0.063	0.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.678	1.677	1.676	1.676	1.677
AP	0.053	0.073		0.063	.063	.063	.063	.063
AQ	0.022	0.042		0.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: DIP Date: 09/08/01

Audited by: K.A Date: 09/08/06

Prototype Approval: Date:

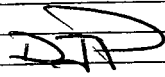
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B	08.04.21	Reformat	KJ/JLM	


DART AEROSPACE LTD		Work Order: 50952
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0.247	.249	.249	.248
AC	0.115	0.150		0.140	0.124	.125	.125	.126
AD	0.040	0.060		0.055	0.055	.055	0.053	.051
AE	0.010	0.020		0.020	0.020	0.020	0.020	.020
AF	0.240	0.260		0.250	0.250	0.250	0.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		0.139	0.140	.140	.140	.140
AI	0.454	0.474		0.467	0.467	.466	.466	.460
AJ	2.779	2.789		2.783	2.783	2.783	2.784	2.782
AK	0.240	0.260		0.250	0.250	0.250	0.250	.250
AL	1.002	1.042		1.033	1.032	1.033	1.034	1.034
AM	0.053	0.073		0.063	0.063	0.063	0.063	.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	.258
AO	1.663	1.683		1.676	1.676	1.676	1.676	1.677
AP	0.053	0.073		0.063	0.063	0.063	0.063	.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: 	Date: 09/08/01
Audited by: M. A	Date: 09/08/06
Prototype Approval:	Date:

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DART AEROSPACE LTD		Work Order: 50952
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		.188	.188	.188	.188	.188
AB	0.240	0.260		.249	0.247	.248	0.247	0.246
AC	0.115	0.150		.127	0.126	0.126	0.126	0.125
AD	0.040	0.060		.047	0.055	0.054	0.054	0.054
AE	0.010	0.020		.020	.020	.020	.020	.020
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		0.140	0.140	0.140	.139	.140
AI	0.454	0.474		0.457	0.468	0.468	0.457	0.456
AJ	2.779	2.789		2.782	2.783	2.783	2.783	2.783
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.035	1.034	1.034	1.035	1.033
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.677	1.675	1.675	1.675	1.677
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: DT **Date:** 09/08/02

Audited by: M.A **Date:** 09/08/06

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	